

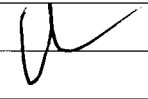
Work Order ID 115407

March-31-14 9:53:25 AM

115407

Page 1

Item ID: D4542-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Retainer, Inner
Start Date: 3/31/14 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 3/31/14 Req'd Qty: 12.00 ***12*** Customer:
Reference: scrap...wrong DXF

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4542	E

105

0.00

105

Small Fab

Memo

0.00

Small Fab

PULL FROM STK:
12 X D4542-5 B115221
SCRAP, MADE TO WRONG DXF

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00


Quality Control

DAS
36
9-89

12X 14/03/31

14-03-31

N 14-03-31

closed at 
Scrapped.

Picklist Print

March-31-14 9:53:25 AM

Page 1

Work Order ID: 115407

115407

Parent Item: D4542-5

D4542-5

Parent Item Name: Retainer, Inner

Start Date: 3/31/14

Required Date: 3/31/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B
12.02.24 as per dwg reva DD verf:EC IPP REV:C 12.05.08 as
per dwg revB DD verf:EC IPP REV:D 13.04.23 as per dwg revD
DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4542-5

Manufactured

No

Each

0.0000

12

D4542-5

Retainer, Inner

115221

Work Order ID 115221

March-18-14 11:41:16 AM

115221

PRELIMINARY ISSUE

Page 1

Item ID: D4542-5

Revision ID:

Item Name: Retainer, Inner

Start Date: 3/18/14 Start Qty: 16.00

Required Date: 4/01/14 Req'd Qty: 16.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: 14-03-19

QC: _____ Date: _____

Tooling:

SPC (Y/N):

Date: _____

Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Qnt
27
9-89

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4542

PE 2 ~~AA~~ Res E

DAS
10
9-89

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1- Cut as per dwg

Prog rev: PE 2

Dwg rev: 022

2- Deburr

0.00

0.00

0.00

110

QC2- Inspect parts off machine FAI/FAIB

110

QC

Quality Control

Memo

20 0 Jm14-03-25

20 0 Jm14-03-25

Work Order ID 115221

March-18-14 11:41:16 AM

115221

Page 2

Item ID: D4542-5

Revision ID:

Item Name: Retainer, Inner

Start Date: 3/18/14 Start Qty: 16.00

Required Date: 4/01/14 Req'd Qty: 16.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling:

SPC (Y/N): _____

Date: _____

Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

DAS
27
9-89

0.00

4/3/25

120

QC

Quality Control

Memo

20

Inspected & per
RUC PFD

125

Chemical Conversion Coat per QSI005 4.1

0.00

125

HandFinish

Hand Finishing

Memo

0.00

20

4/3/26

127

QC7-Inspect Chemical Conversion Coat

0.00

DAS
27
9-89

0.00

4/3/26

127

QC

Quality Control

Memo

20

Inspected & per
RUC PFD

Work Order ID 115221

115221

Page 3

March-18-14 11:41:16 AM

Item ID: D4542-5

Revision ID:

Item Name: Retainer, Inner

Start Date: 3/18/14 Start Qty: 16.00

Required Date: 4/01/14 Req'd Qty: 16.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____

SPC (Y/N): _____

Date: _____

Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *S/S30* 0.00

Z0

MAR 26 2014

DAS
28
9-89

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

ML5 14-03-26

MF 14-3-26

POSITIVE RECALL

EFFECTIVE *14/3/14*

AUTH *14*

RELEASED *16*

DATE *14/3/16*

DAS
27
9-89

Release Dwg on for 14/3/26
Rev E

Picklist Print

March 18-14 11:41:19 AM

Page 1

Work Order ID: 115221

115221

Parent Item: D4542-5

D4542-5

Parent Item Name: Retainer, Inner

Start Date: 3/18/14

Required Date: 4/01/14

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B
12.02.24 as per dwg revA DD verf:EC IPP REV:C 12.05.08 as
per dwg revB DD verf:EC IPP REV:D 13.04.23 as per dwg revD
DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.032

Purchased

No

100

sf

410.6032

0.208

4

M6061T6S 0.32

6061-T6 Sheet 0.032"

**

Jm14-03-25

Location

Loc Qty

Loc Code

MAT021

410.60317

123483

8.57

m125822

17

m127272

128.75317

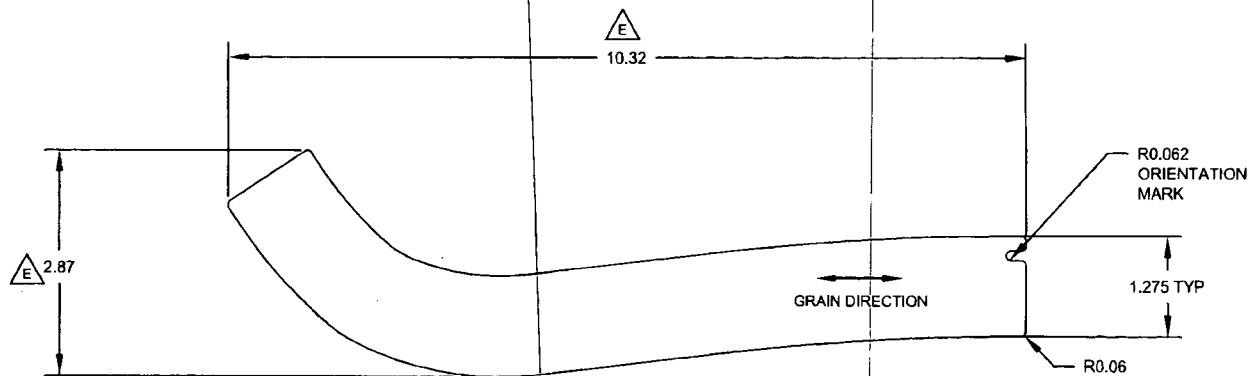
m128054

256.28

125054

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



D4542-5 RETAINER, INNER
(TOP CORNER)

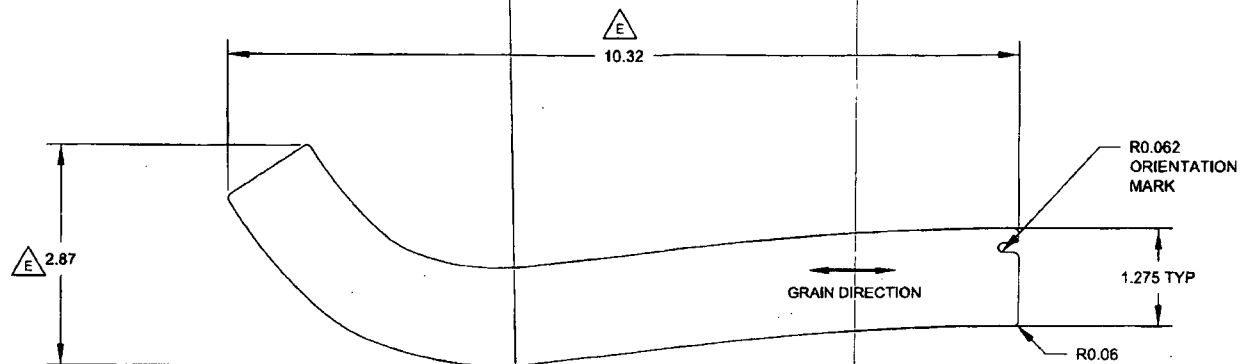
PRELIMINARY E2
14.03.17 (AJS)

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4542-5-REVE.DXF"

alD 115221

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE2
MFG. APPR.		D4542	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
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D4542-5 RETAINER, INNER
(TOP CORNER)

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DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D4542	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RETAINER, INNER	NTS
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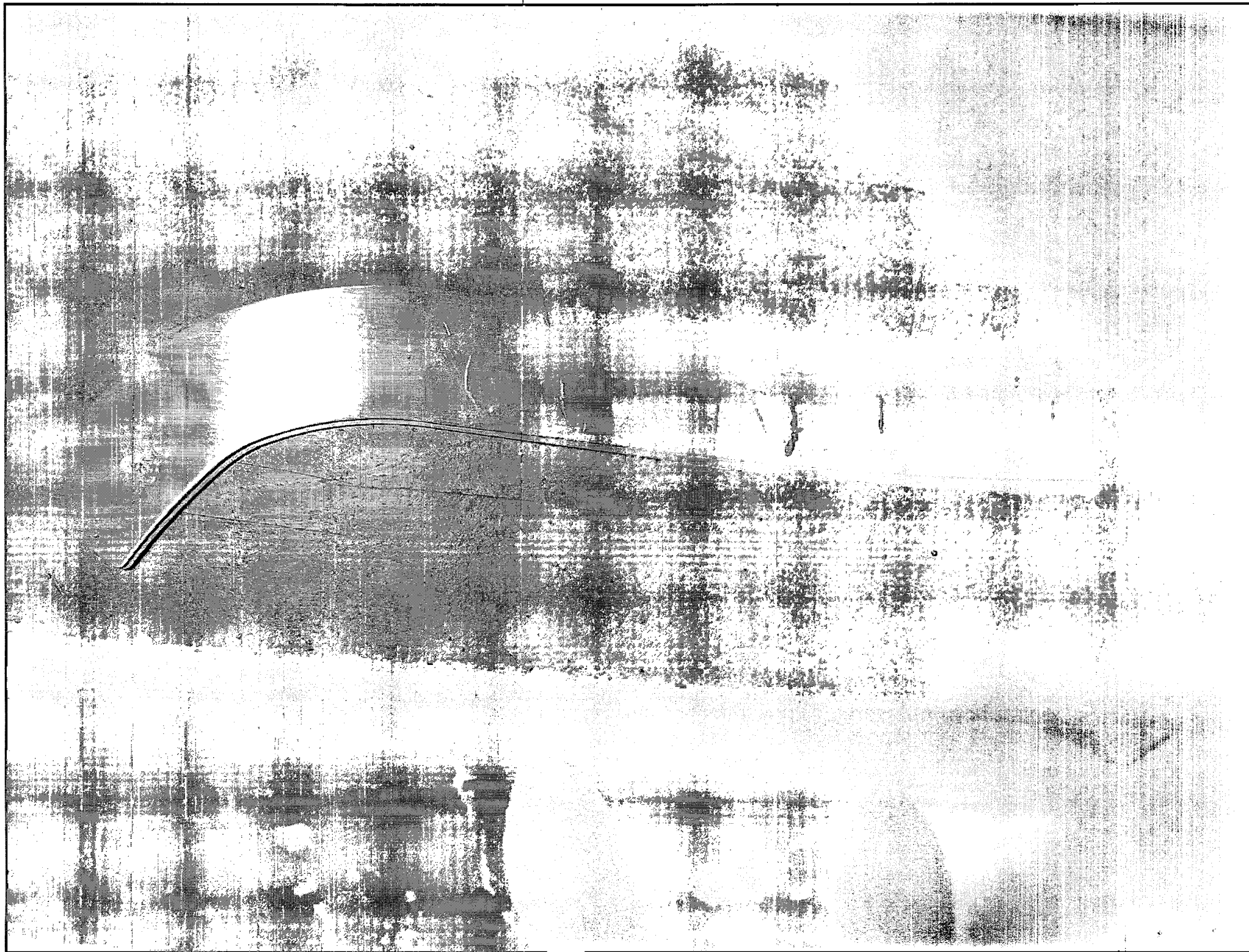
Non-Conformance Report

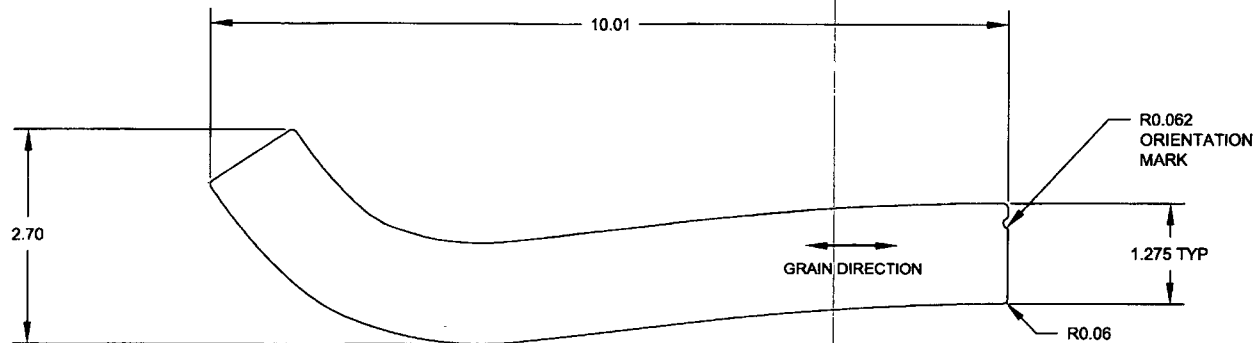
Reviewed			
DQA:		Printed on: March-31-14	
Date:			
Details			
Raised Date 31/03/2014	Status Open	Owner Forbes, Nigel	Number NCR14-3681
Target Date	Standard	Severity	
Process Customer Feedback		Audit	
Raised By Person Bell Helicopter Textron Inc.	Raised Against (Department or Supplier) Manufacturing		Fault Category
Details Customer reports replacement parts received for kit are too short.			
Keywords		Product D206-817-011	
Document		Root Cause	
Closed By	Closed Date	Resolution	
Corrective Action			
Target Date	Owner	Closed Date	Closed By
Details			
Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Bellavance, Marc	31/03/2014	31/03/2014
Determine source of discrepancy.		W/O says D4542-5 was made to Rev. E however photos shows otherwise. Customer confirms that the parts were not altered. Parts in photos not to drawing. Review of DXF file used to cut part confirms this: DXF labelled as Rev. E while it is Rev. D.	
2	Bellavance, Marc	31/03/2014	
Enter no charge in system for qty(4).			
3	Duval, David	31/03/2014	
Ensure D4542-5 DXF matches D4542 Rev. E drawing.			

4	Downing, Eric M	04/04/2014	
This should have been caught upon filling out the D4542-5 FAI sheet. Ensure the FAI sheet was updated and/or retrain employee.			

Verification & Review			
Target Date	Owner	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	





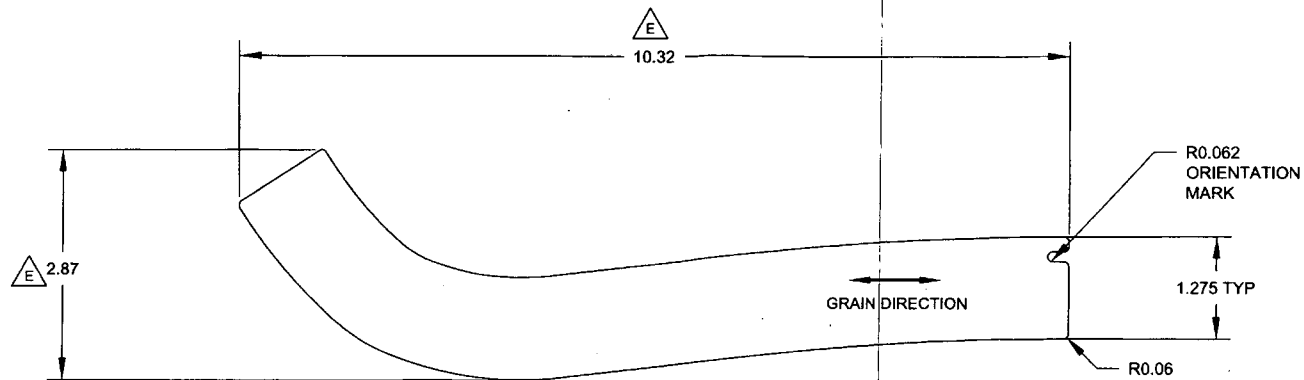
D4542-5 RETAINER, INNER
(TOP CORNER)

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RELEASED
2013-04-23
MB

DESIGN	9P	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA	
DRAWN	9P		
CHECKED	ASS	DRAWING NO.	REV. D
MFG. APPR.	SS	D4542	SHEET 4 OF 5
APPROVED	IMP	TITLE	SCALE
DE APPR.	CH	RETAINER, INNER	NTS
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D4542-5 RETAINER, INNER
(TOP CORNER)

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DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4542	SHEET 4 OF 5
APPROVED		TITLE	SCALE
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